

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021064**Date Inspected:** 30-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Liu dao feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Service Platform Railing**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA Inspector observed the following work in progress:

SMAW welding of weld joint identified W5-SB1-082-061, located on Steel barrier joint W5-SB1-082, welder is identified as 201074, ZPMC Quality Control (QC) is identified as Mr. Mai Quin Li. The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

FCAW welding of weld joint identified SB5 & SB6, located on Service Plate form, welder is identified as 067752, ZPMC Quality Control (QC) is identified as Mr. Mia quin li. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

FCAW welding of weld joint identified Service Platforms SP4, welder is identified as 159416, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. The welding variables recorded by QC appeared to comply with

WELDING INSPECTION REPORT

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WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified SP4, Service Plate forms, welder is identified as 203805, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. AB/F Quality Assurance is identified as Kang Yi. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified SP7-G, Service Plate forms, welder is identified as 062265, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. AB/F Quality Assurance is identified as Kang Yi. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

FCAW welding of weld joint identified SP7, Service Plate forms, welder is identified as 059378, ZPMC Quality Control (QC) is identified as Mr.Liu dao feng. AB/F Quality Assurance is identified as Kang Yi. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

OBG Bay # 16

NDT

The following NDT performed ZPMC NDT notification 07991

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 16:45 hours. The members are identified as follows OBG, Steel Barrier, The weld designations reviewed are as follow: W5-SB26-001-019, 050, 081.

OBG Bay # 28

NDT

The following NDT performed ZPMC NDT notification 07985:

This QA inspector performed UT testing on 10% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 10:30 hours. The members are identified as follows OBG, Spice Plates, The weld designations reviewed are as follow:

SA3117A-001~006-001, 002

SA3116D-001~008-007, 008

SA3102C-001~011-005, 006

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Humphrey, Delbert	Quality Assurance Inspector
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Reviewed By:	Hall, Steven	QA Reviewer
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